

HELLER Machining Centres

Technical Data MCH-C

HELLER
Machines

Model			MCH 280 C	MCH 350 C	MCH 450 C
Working area	Longitudinal stroke (X axis)	mm	1.000	1.250	1.600
	Vertical stroke (Y axis)	mm	1.000	1.000	1.200
	Transverse stroke (Z axis)	mm	1.100	1.300	1.700
Feed forces	X and Y axis with duty cycle = 40 %	N	15.000		
	Z axis with duty cycle = 40 %	N	17.500		
Speeds	in X, Y and Z axis/rapid traverse	mm/min.	50.000	50.000	40.000
	Acceleration	m/s ²	4,0		
Machining unit	Speed range	1/rpm.	6.000 (8.000 opt.)		
	Drive power at duty cycle S1 - 100 %	kW	28		
	Drive power at duty cycle S6 - 40%	kW	43		
	Torque at duty cycle S1 - 100 %	Nm	536		
	Torque at duty cycle S6 - 40 %	Nm	822		
	Division swivel unit	degrees	360.000 x 0,001°		
	Swivel time from H to V position incl. clamping	s	3,5		
Pallet design		mm	S 630 x 630	S 800 x 800	S 800 x 1.000
Workpiece	Max. diameter	mm	900	1.250	auf Anfrage
	Max. height	mm	1.000	1.200	1.450
	Max. weight	daN	800	1.250	2.500 (4.000 opt.)
Tool	Spindle taper	SK/HSK	50/A100		
	Chain-type magazine (standard)	places	50/100		
	Rack-type magazine (optional)	places	106/234/405/590		
Chip-to-chip-time	VDI 2852 (lightweight tool)	s	6,8	7,1	8,2
Rotary feed table	Indexing division	degrees	360.000 x 0,001°		
	Max. speed	rpm	25	10	10
Positioning tolerance	VDI / DGQ 3441	mm	0,009	0,010	0,010
Integrated process monitoring	Tool	mm	Ø > 5		
Dimensions (Basic machine)	Length	mm	6.600	7.400	10.400
	Width	mm	5.100	5.200	6.200
	Height	mm	4.600	4.600	5.000
Weight (Basic machine)		daN	23.000	26.000	30.500
CNC control	Siemens SINUMERIK 840 D		■		
Digital drive technology	Siemens SIMODRIVE 611		■		